

Work Order ID 73140

Friday, August 26, 2011 6:49:37 AM



Page 1

Item ID: D3822-1KGY

Accept



Setup Start



Revision ID:

Item Name: Vertical Tunnel, LH-Grey

Stop



Start Date: 8/26/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 11-08-09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3822-1	Rev. C

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

x2

DL
11/09/07

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

x2

DL
11/09/07

Temp: 150°F

Time IN: 4:30 pm 11/09/06

Time OUT: 2:00 am 11/09/07

W/O:		WORK ORDER CHANGES					
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Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA025 using tool DT9073
Dwg Rev: C
Folio Rev: B

x2

Dh
11/09/07

120

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

x2

Dh
11/09/07

130

0.00



QC

Memo

0.00

Quality Control

QC8- Inspect parts - second check

S. W. 11/09/07

x2

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Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00



Hand Thermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

x2

DH
11/09/07

150

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Complete FAI document

x2

DH
11/09/07

160

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

Sublog/07



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Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPN 73140

0.00

Packaging

11/9/11 (2)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/11
mf
11-09-01

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NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 6:49:34 AM

Page 1

Work Order ID: 73140

Parent Item: D3822-1KGY

Parent Item Name: Vertical Tunnel, LH-Grey



Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

IPP Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MKYD6185S.080-P3-
52068

Purchased

No

100

sf

472.8479

7.8

15.60780



Kydex steel grey



Location

therm

Loc Qty

472.8478542

472.847854

Loc Code

111807

15.60780 sf

Wh
u/08/07

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DART AEROSPACE LTD		Work Order: 73140
Description: Vertical Tunnel, LH		Part Number: D3822-1KIV/KGY
Inspection Dwg: D3822	Rev: C	Page: 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: Sh.

Date: 11/09/07

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.8	Min	1.04"	✓		Visual THOI	
0.3	Min	0.391"	✓		Visual THOI	
0.55	Min	0.66"	✓		Visual THOI	
0.040	Min	0.061"	✓		ULTRA	
0.050	Min	0.067"	✓		ULTRA	

Measured by: Sh.

Date: 11/09/07

Audited by: S

Date: 11/09/07

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ <u>Sh</u>	<u>M</u>

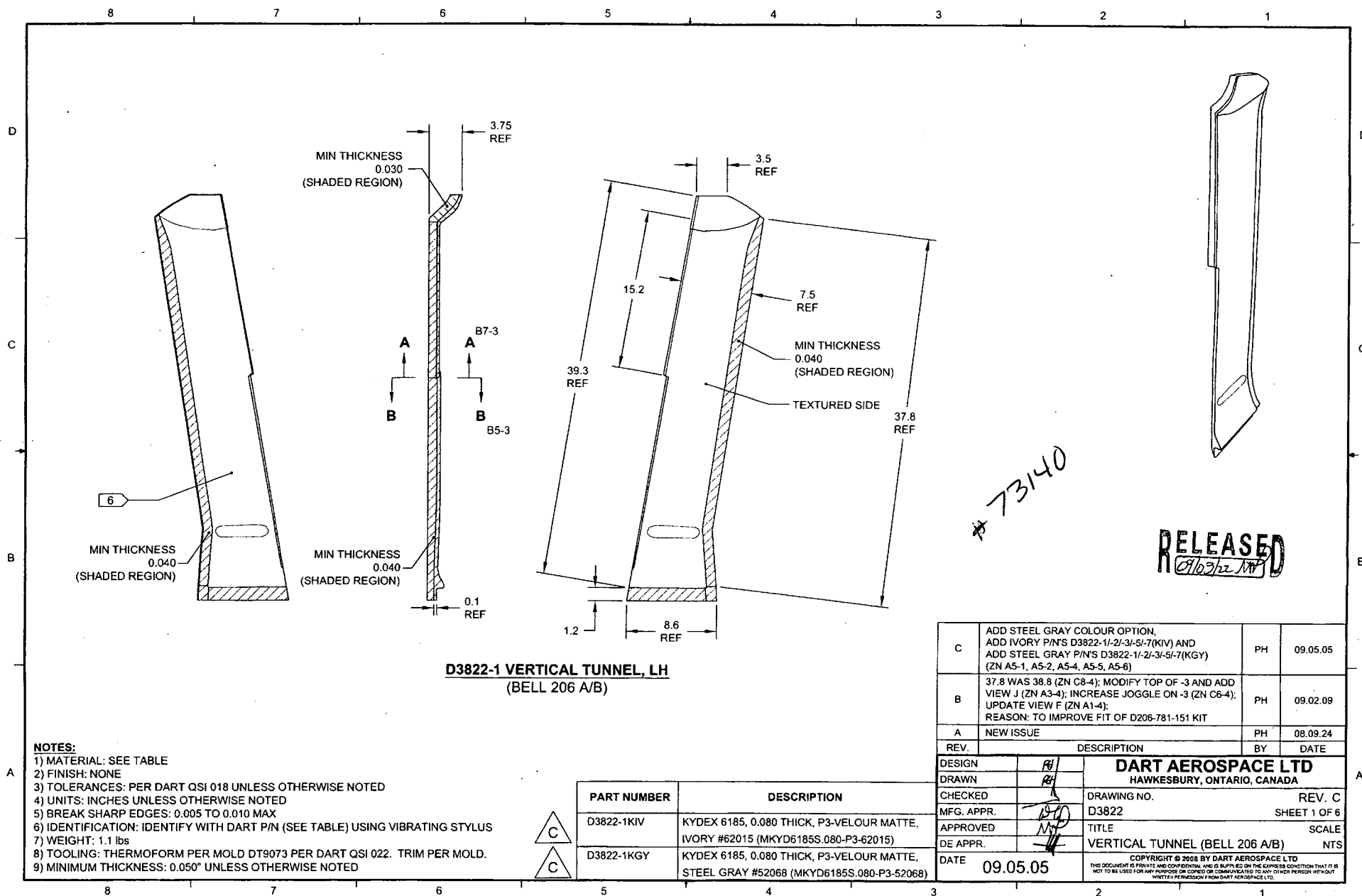
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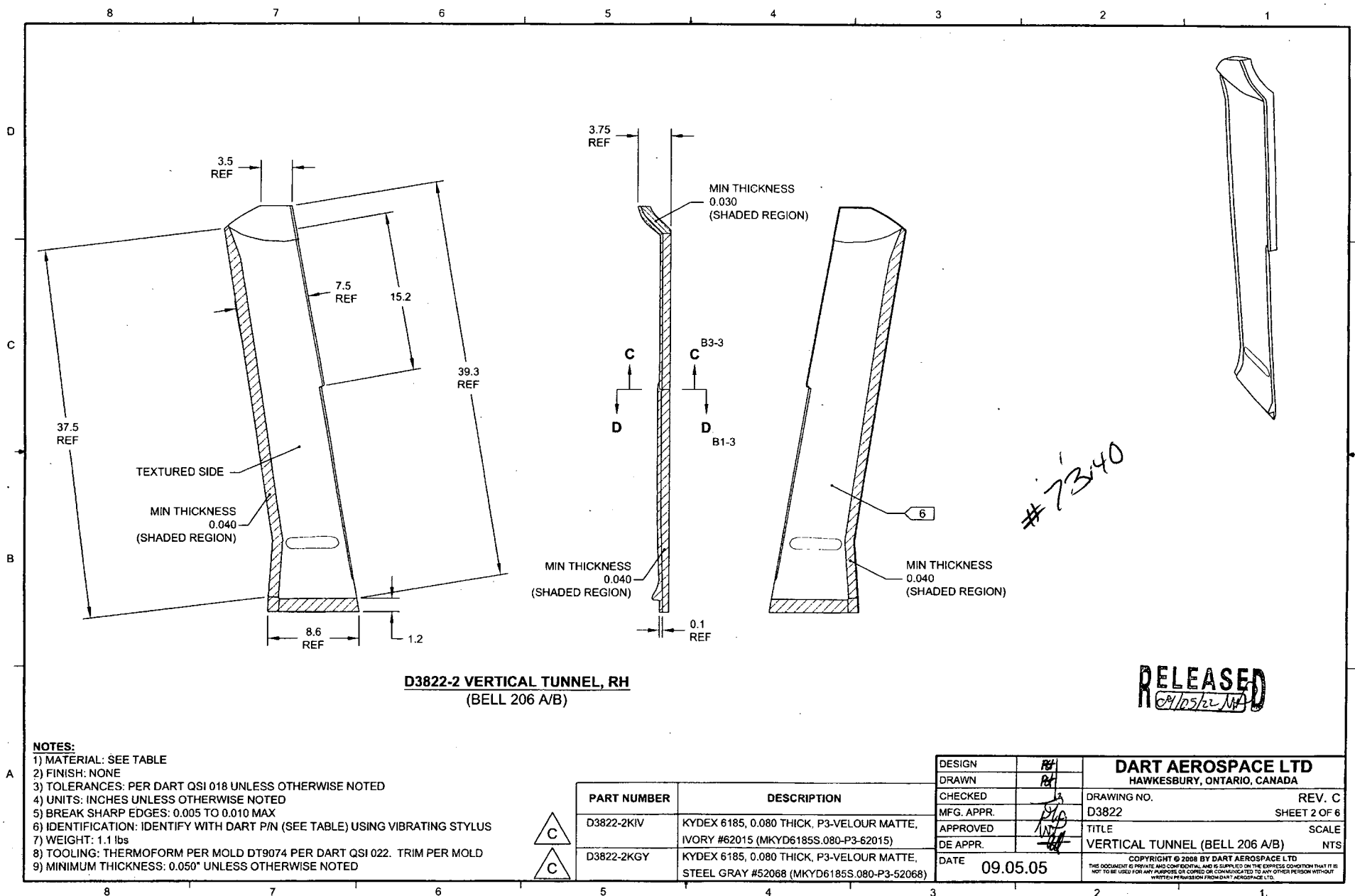
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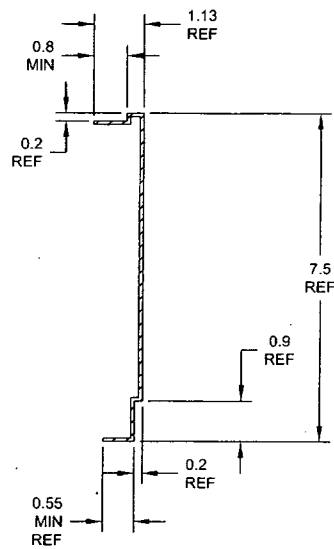
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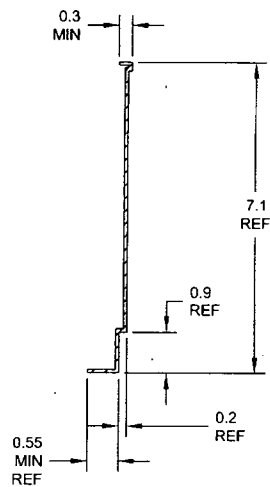
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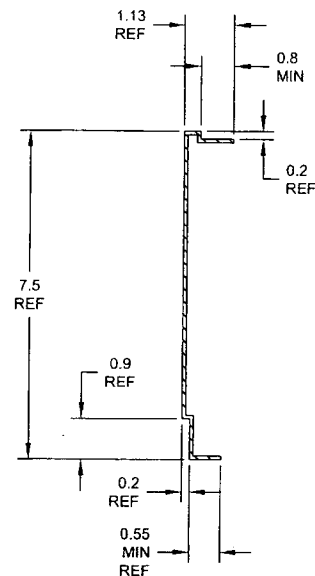
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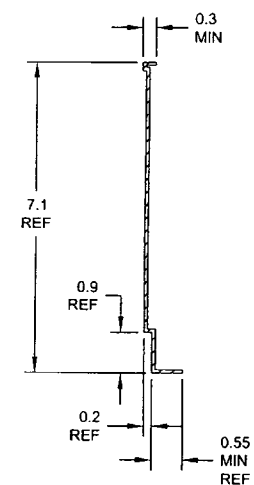
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

73140

RELEASED
09/25/2005

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3822	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		VERTICAL TUNNEL (BELL 206 A/B)	NTS
DATE	09.05.05	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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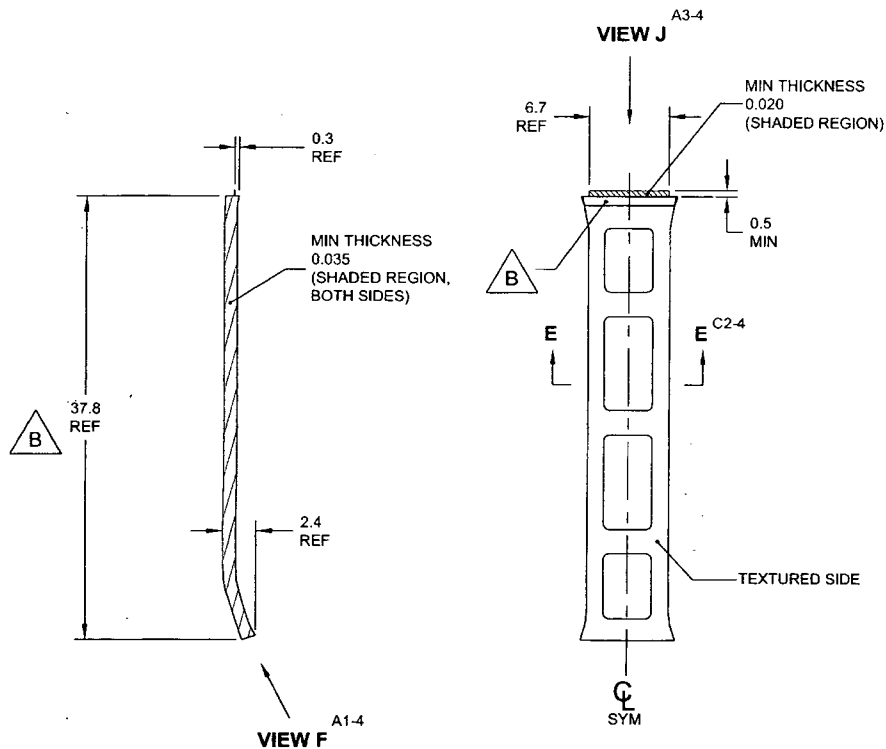
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D

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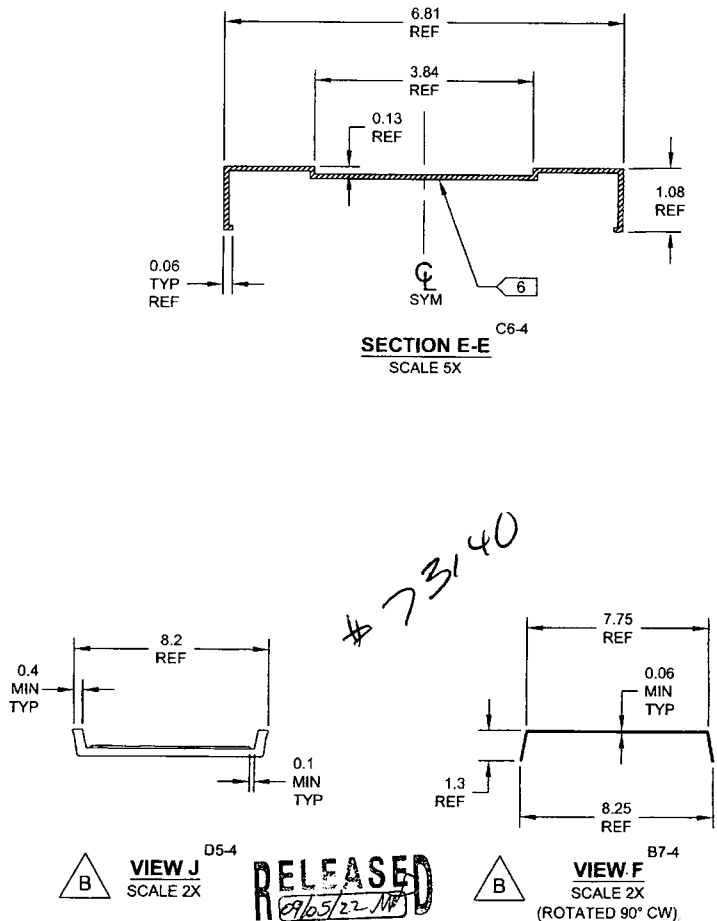


D3822-3 VERTICAL TUNNEL, AFT CENTER
(BELL 206 A/B)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3822-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)



RELEASED
09/05/22

DESIGN	REV. C
DRAWN	SHEET 4 OF 6
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	09.05.05
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	
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VERTICAL TUNNEL (BELL 206 A/B)	
NTS	
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8 7 6 5 4 3 2 1

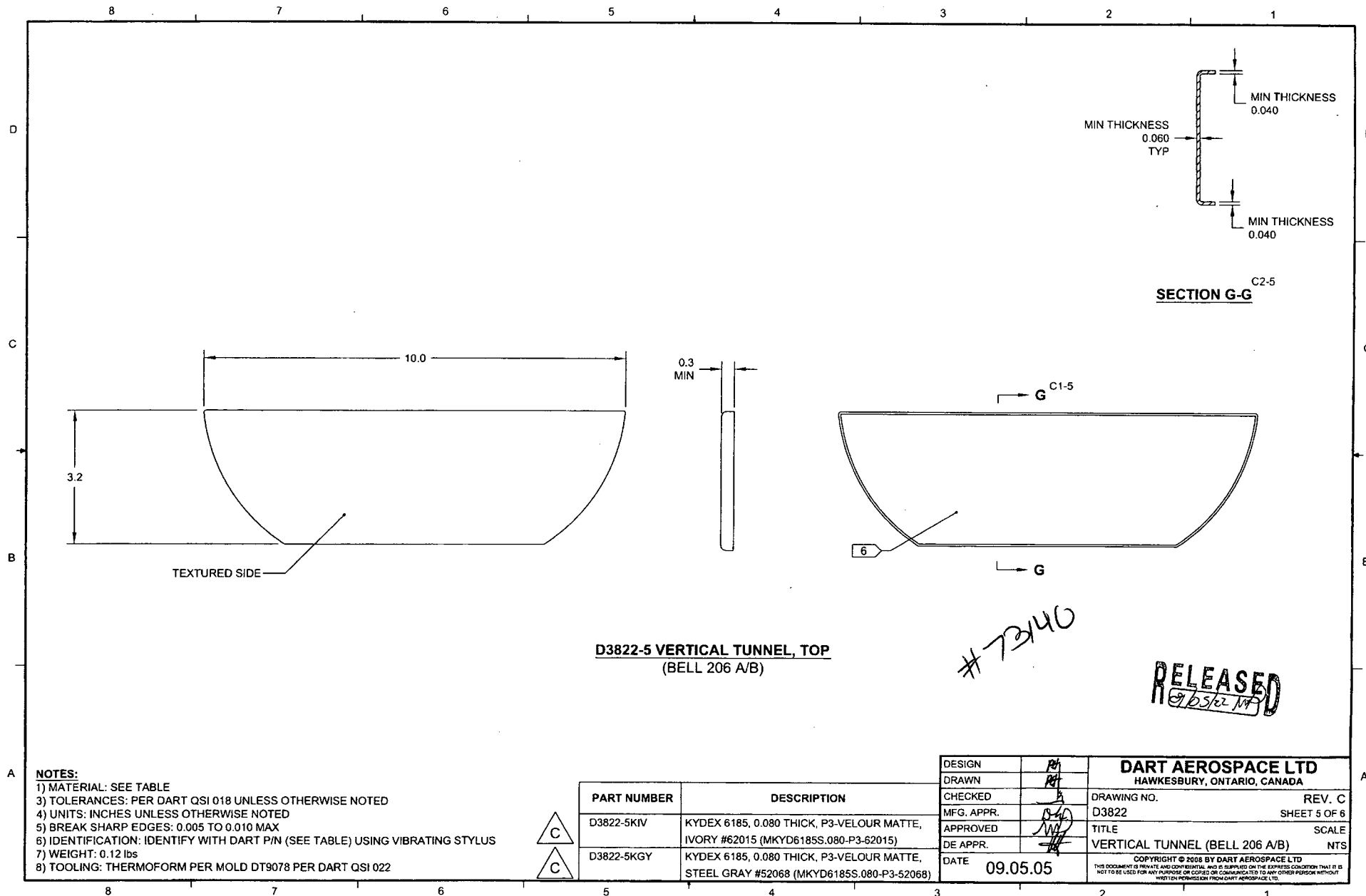
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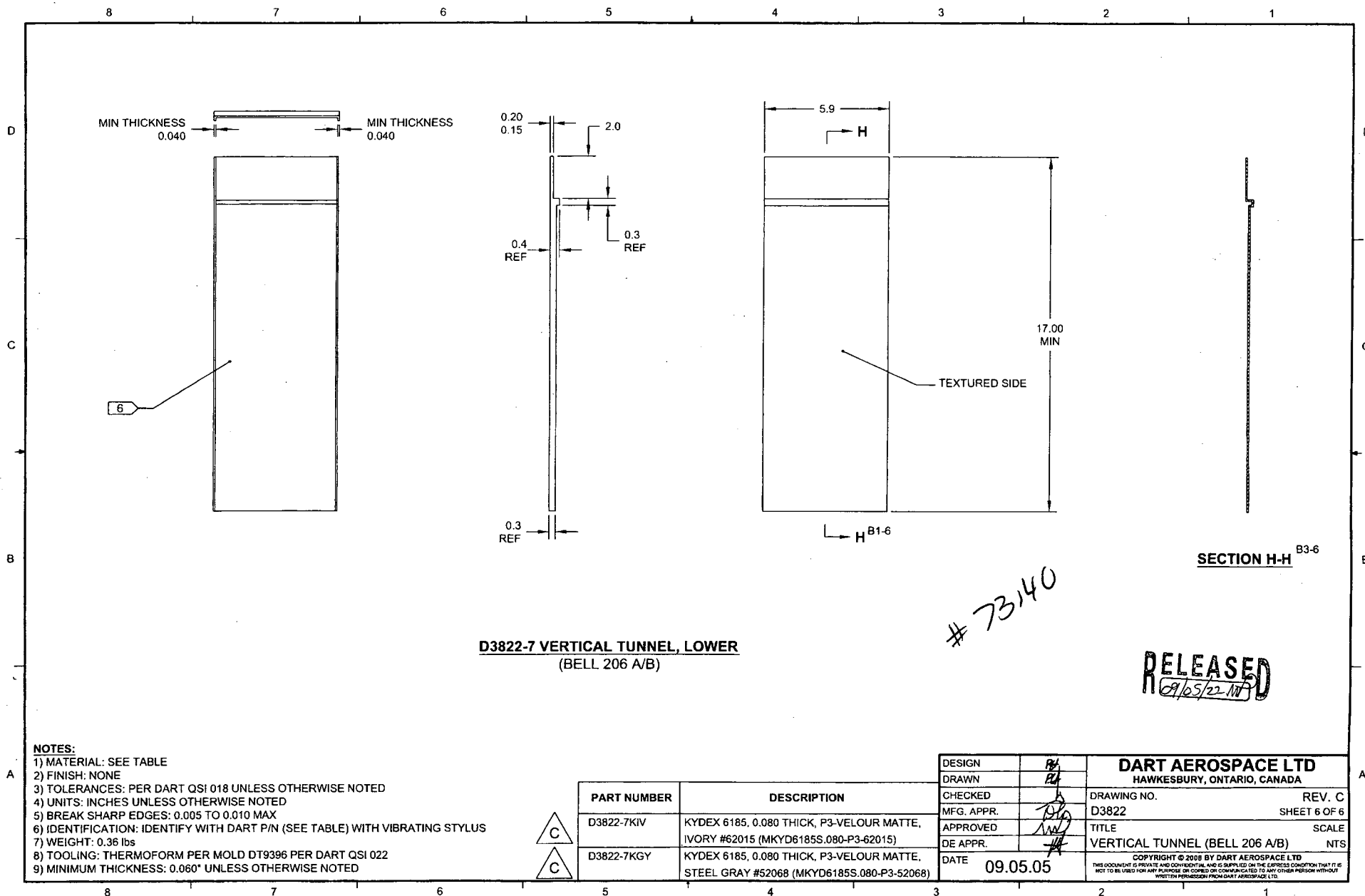
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09/05/22-11/11

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